

Work Order ID 96822

February-07-13 8:46:07 AM

96822

Ship March 25

Page 1

Item ID: D3628-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Cupped Washer

Start Date: 2/07/13 Start Qty: 500.00

500

Cust Item ID:

Required Date: 3/22/13 Req'd Qty: 500.00

500

Customer:

Reference:

Approvals: Process Plan: *ML5*

Date: *13-02-07* Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3628

C

100

0.00

100

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: *19046*

Email or Ship DXF file to vendor

Laser Cut D3628-1 flat pattern and form as per Dwg D3628

Possible Supplier: GFI

Material release note is required

CY 13/02/07 500

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

Ensure material certification is attached

13/2/13 500

Work Order ID 96822

February-07-13 8:46:07 AM

96822

Page 2

Item ID: D3628-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cupped Washer

Start Date: 2/07/13 Start Qty: 500.00

500

Cust Item ID:

Required Date: 3/22/13 Req'd Qty: 500.00

500

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

DAS
15
9-89
132 13

500

130 Identify as per dwg & Stock Location: ST 1000 0.00***130***

Packaging

Memo

0.00

Packaging

500x

SD
13-2-14.

140 QC21- Final Inspection - Work Order Release 0.00

140

QC

Memo

0.00

Quality Control

13/2/14 DJ

MF
13-2-14

Picklist Print

February-07-13 8:46:11 AM

Page 1

Work Order ID: 96822

96822

Parent Item: D3628-1

D3628-1

Parent Item Name: Cupped Washer

Start Date: 2/07/13

Required Date: 3/22/13

Start Qty: 500.00

Required Qty: 500.00

Comments:

IPP Rev:A New Issue 07-05-28 JLM

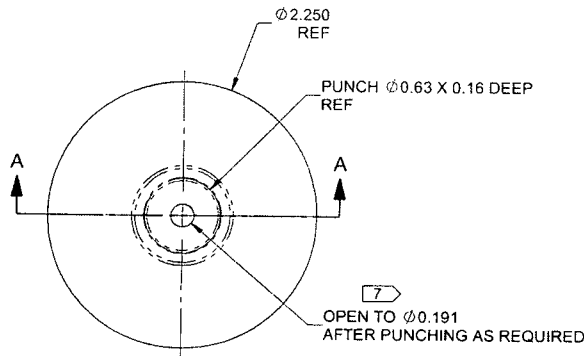
IPP Rev:B Removed Powder 07-07-11 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3628-1P		Purchased	No			110	Each	0.0000	1	500			
D3628-1P									**				
CUPPED WASHER													

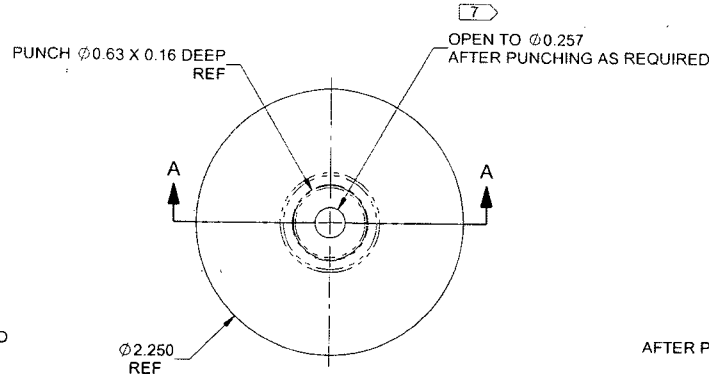
10/2/13 (500)

UNCLASSIFIED
 SUBMITTED
 WITH
 V.L.

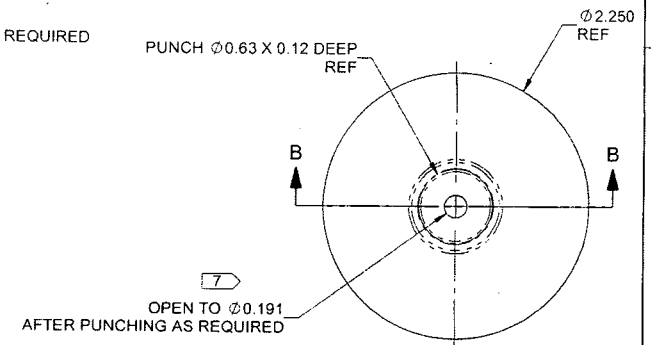
NO. 96822 MJS
 13-02-07



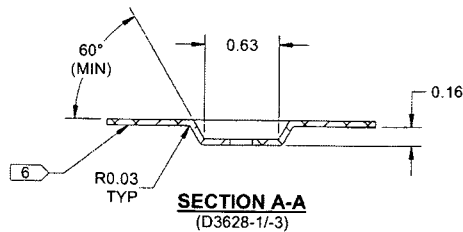
D3628-1 CUPPED WASHER



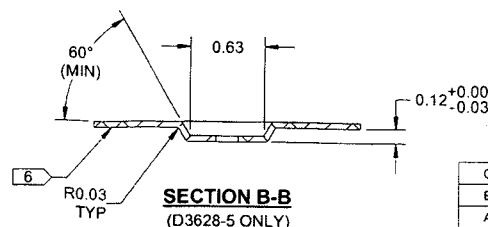
D3628-3 CUPPED WASHER



D3628-5 CUPPED WASHER



SECTION A-A
 (D3628-1/3)



SECTION B-B
 (D3628-5 ONLY)

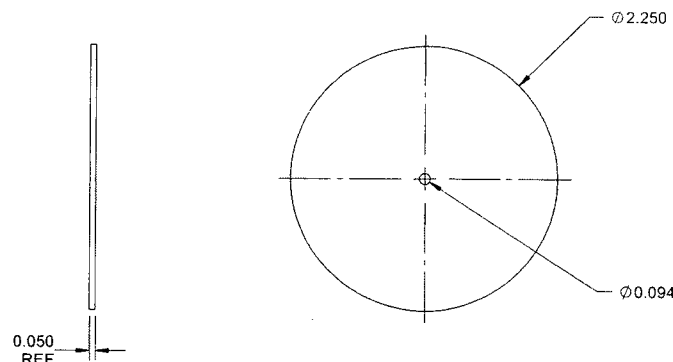
NOTES:

- 1) MATERIAL: MADE FROM D3628-1F
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.5
- 7) WHEN DRILLING OUT THE CENTRE HOLE AFTER PUNCHING, ENSURE THAT THE HOLE IS DRILLED CONCENTRIC TO THE CUPPED AREA; WITHIN 0.03
- 8) WEIGHT: 0.02 lbs

RELEASE
 2012-05-07

C	UPDATE DWG TO CURRENT STD; ADD -5, ZN C1-1.	DC	12.04.19
B	REMOVE POWDER COAT	CB	07.07.09
A	NEW ISSUE	CB	07.06.08
REV.	DESCRIPTION	BY	DATE
DESIGN	BC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	BC		
CHECKED	BE	DRAWING NO.	REV. C
MFG. APPR.	BE	D3628	SHEET 1 OF 2
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	CUPPED WASHER	NTS
DATE	12.04.19	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

96822



D3628-1F FLAT PATTERN

RELEASED
2012-05-07

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.050 THICK)
ANNEALED, 2B FINISH
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

DESIGN	DC	DART AEROSPACE LTD	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BE	DRAWING NO.	REV. C
MFG. APPR.	BE	D3628	SHEET 2 OF 2
APPROVED	140	TITLE	SCALE
DE APPR.	14	CUPPED WASHER	NTS
DATE	12.04.19	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO19046

Purchase Order Date 2/07/13

PO Print Date 2/07/13

Page Number 1 of 1

Order From : VC-GFI001
GFI
180 AVENUE LABROSSE
POINTE CLAIRE, QC H9R 1A1
CA

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	514 630 4877	Requisition Nbr	
Vendor Fax	514 630 4849	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	CAD
		FOB	Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D3628-1P	CUPPED WASHER	2/28/13 Yes	500.00 Each	FedEx PI collect	\$2.4160	\$1,208.00

Special Inv: AS PER DWG D3628 REV. C
B96822

PO Total: \$1,208.00

Pehe 02/08/2013

No substitution or deviation without
consent.

Certificate of Conformity or Material
Certification required - YES NO

Change Nbr: 1

Change Date: 2/07/13



180 AVENUE LABROSSE
POINTE-CLAIRE, QC, CANADA H9R 1A1
TÉL.:(514) 630-4877 - FAX:(514) 630-4849

GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.



BON DE LIVRAISON / SHIPPING MEMO

DATE DE LIVRAISON / SHIPPING DATE			N° DE BON DE LIVRAISON / SHIPPING MEMO NO.	PAGE
JR - DY	MO - MO	AN - YR		
11	02	13	0507052	1/1



VENDU À / SOLD TO

EXPÉDIÉ À / SHIP TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

CODE DE CLIENT / CUSTOMER CODE	N° DE CONTRAT / JOB NO.	VOTRE N° DE COMMANDE / YOUR PURCHASE ORDER NO.	EXPÉDIÉ PAR / SHIP VIA
DART	GFI-0299	0262875	PO18907

QUANTITE / QUANTITY	N° DE PIÈCE / PART NO.	DESCRIPTION
---------------------	------------------------	-------------

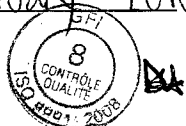
500 D3628-5P

CUPPED WASHER

ITEM 3
C OF C REQ'D

MFG. JOB# 30762875-001 QTY 500 pcs.

DUE DATE: 15 February 2013



EXPÉDITEUR / SHIPPER	N° DE BON DE LIVRAISON / SHIPPING MEMO NO.
----------------------	--



REÇU PAR / RECEIVED BY

DATE

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION.
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

CERTIFICATE OF COMPLIANCE CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO.	4	OUR JOB NO	J0262875	SHIPPING MEMO	0507052	
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
-	500 PCS	PO18907	D3628-5P	C	CUPPED WASHER	C
MATERIAL		SUPPLIED BY		MAT. REL. NO.		
AMS 5513 304 ANN		TW METALS / NORTH AMERICAN STAINLESS		H/N D5J4		

	PROCESS	PROCESSOR	RELEASE NOTE #
1	FIRST ARTICLE INSPECTION REPORT ON FILE	GFI	N/A
2	REF. GFI MANUFACTURING JOB NUMBER J0262875-001 (500 PCS)	GFI	N/A
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE **11 FEBRUARY 2013**

G.F.I. Q.C. REP.

Signature



METALS
O'Neal High-Performance
Metals Group

CERTIFICATIONS

FRAUD AND FALSIFICATION STATEMENT

The recording of false, fictitious or fraudulent statements or entries on this document may be punished as a felony under statutes including federal law. Title 18 chapter 47.

CERTIFICATE OF COMPLIANCE

This certificate of compliance certifies that the material supplied on the purchase order number below complies in all respects with the material description and procurement specifications.

MERCURY FREE STATEMENT

TW Metals certifies that the supplies furnished under this contract contain no metallic mercury or mercury compounds, and have not come in contact with mercury or alpha bearing instruments while in the possession of TW Metals Inc.

Customer Name: GFI, Inc
Purchase Order No.: 0081273
Item number: 0001 Shipper/Invoice No.: 03301184
Material: 304-2B Manufacturing Mill: United Performance
Specification: AMS 5373 Heat / Lot No. D5J4
Size: .050 Quantity: 1 pc
Signature: Janice Clark Date: 1/18/13



METALLURGICAL TEST REPORT

6870 Highway 42 East
Ghent, KY 41045-9615
(502) 347-6000

Certificate: 761091 02

Mail To:

UNITED PERFORMANCE METALS
3475 SYMMES ROAD
HAMILTON, OH 45015

Ship To:

UNITED PERFORMANCE METALS
3475 SYMMES ROAD
HAMILTON, OH 45015

Date: 8/13/2012 Page: 1

Customer: 0018 001

Steel: 302/304/304L

Finish: 2B

Your Order: 01020912

NAS Order: AN 0527020 01

Corrosion: ASTM A262/02aE; 180Bend-OK

PRODUCT DESCRIPTION:

S/S COIL, C.R. ANNEALED & PICKLED; UNS 30400/30403/30200
ASTM A240/11b, A480/11b, A666/10; ASME SA240/11a, SA480/11a, SA666/11a
CHEM ONLY ON FOLLOWING ASTM: A276/10, A479/11, A484/11, A312/11
CHEM ONLY ON FOLLOWING ASME: SA312/11, SA479/11
AMS 5511H/5513J/5516P XMRK; MIL-S-5059D AMD3 (X CRN MEAS); MIL-4043B
NACE MR0175/ISO 15156-3:2003 A, MR0103/07; QQS766D-A X MAG PERM
MIN. SOLUTION ANNEAL TEMP 1900F, WATER QUENCHED
FMI 304L/304/302; AMS 5511H

REMARKS:

Mat'l is Free of Mercury Contamination. No weld repairs.
EN 10204:2004 3.1; RoHS Compliant
Material is Free of Radioactive Contamination
NAS Steel Making Process: EAF, AOD, & Cont. Casting
Product Mfg. by a Quality Mgt. Sys. in Conf. w/ISO 9001
*Melted & Manufactured in the USA; Mat'l is DFARS Compliant

Product ID	Supplier ID	Thickness	Width	Weight	Length	Mark	Pieces	COMMODITY CODE
03D5J4 A	* 03D5J4	.0500	48.0000	28,630	COIL	3453.5	11	1

CHEMICAL ANALYSIS

CM(Country of Melt) ES(Spain) US(United States) ZA(South Africa) JP(Japan)

Chemical analysis per ASTM A751/01

HEAT Supplier#	CM	C %	CR %	CU %	MN %	MO %	N %	NI %	P %	S %
D5J4 D5J4	US	.0142	18.2655	.3965	1.7710	.2950	.0722	8.0170	.0320	.0010
Lab Check:		.0153	18.1890	.3960	1.7199	.3038	.0790	8.1182	.0147	.0014
	SI %									
		.2735								
Lab Check:		.2498								

MECHANICAL PROPERTIES

Product Id	Supplier Id	UTS KSI	.2% YS KSI	ELONG %-2"	Hard RB	Tail Hard	Grain No.	D Fer F.N.
03D5J4 A	03D5J4	FT 94.00	47.96	45.54	86.00	85.50	8.50	4.50

ACCEPTED BY

REVIEWED BY Q.C.

Date 8-15-12 by PI

NAS hereby certifies that the analysis on this certification is correct based upon the results and the accuracy of the test methods used, the material meets the specifications stated. These results relate only to the items tested and this report cannot be reproduced, except in its entirety, without the written approval of NAS.

Technical
Dept. Mgr.

ERIC HESS

8/13/20

UNITED PERFORMANCE METALS
This is to certify that in accordance with the records in our files the material shipped on your purchase order conforms to the following:
3475 Symmes Road Hamilton, OH 45015

Size: 48 X 96
P.O.: M4523041
Part#: 47024
Sales #: 01194817
Quantity: 13

Description: 304/304L ANN 048-052 AMS5513.5511
Customer: TW Metals
SN: 000008302012

Authorized Signature
Lynne Harper